

Date: Tuesday, 7/1/2008 10:45:09 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 40148	
Estimate Number : 10106	
P.O. Number :	Part Number : D2012111
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D2012-111 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 38936	Material :
Written By :	Due Date : 7/20/2008 Qty: 40 Um: Each
Checked & Approved By : <u>08.07.01</u>	
Comment : Est: C 00.05.02 Now laser cut EC	
est D 07.01.24 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0226 sf(s)/Unit Total : 0.9030 sf(s)

304/316 Stainless Steel .063 Sheet

Batch: 107675 B 8-7-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2012-111

Dwg Rev: AProg Rev: AB 8-7-18

(49)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-7-18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Sootal/25 49 counters

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

08/07/25 49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 40148

Part Number: D2012111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/08 (+49)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *578*

C 8/1/28

(49)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/01

Job Completion



MF 08-07-31

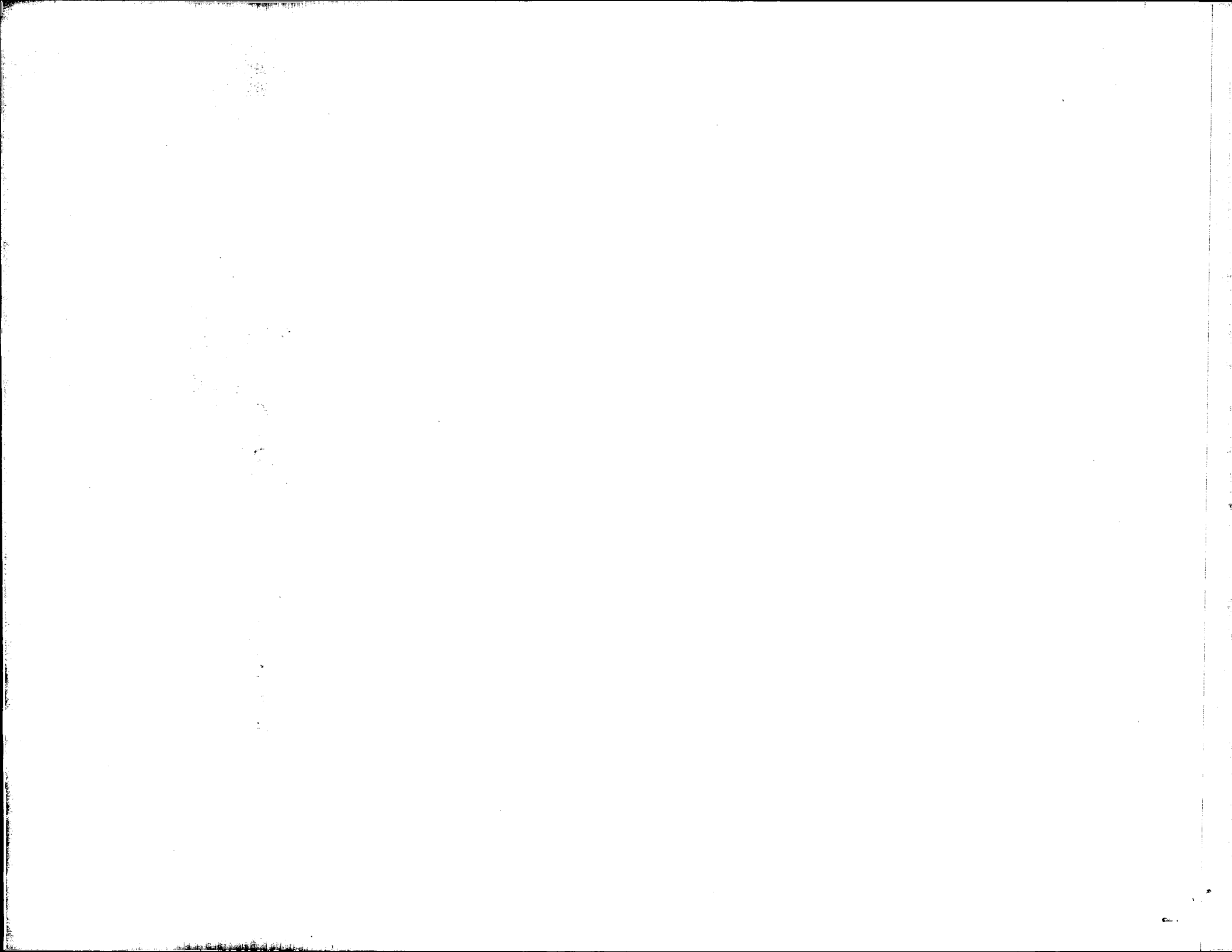
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

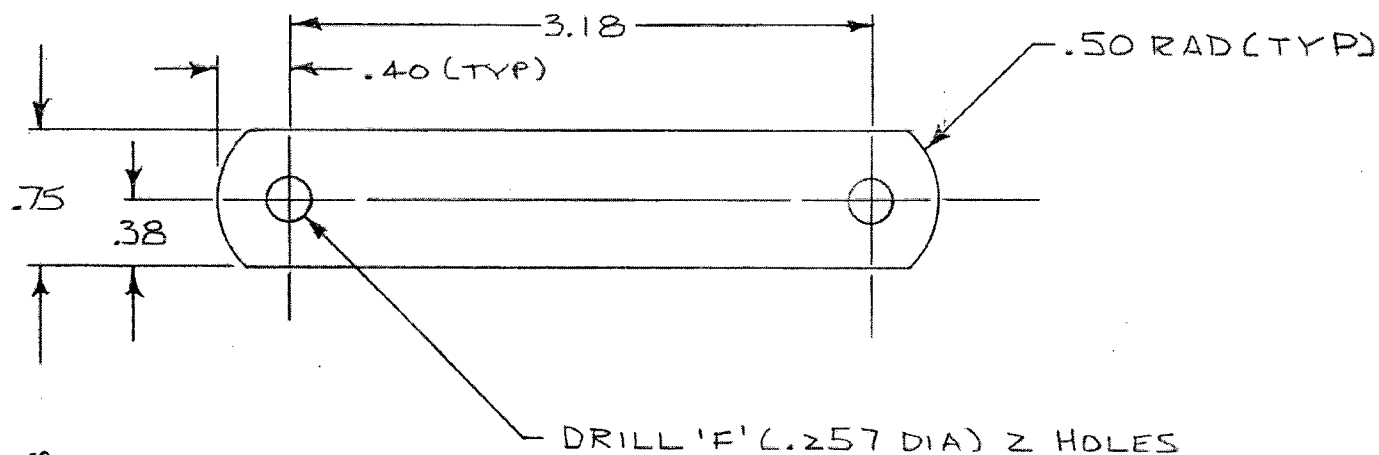
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40148



NOTES: 1. MAT'L AISI 304/316 CRES
.063 THICK

D2012-111

A		REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER HAS 523		PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
44		DRAWN			BASIC CODE		CONTRACT NO.		DATE		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA	
25		APPROVED			D=HOLE DASH=NO OF SHEETS C=COUNTERSINK		LENGTH DASH NO. W=SPOTWELD		DRAWN HATTON		06/03/92	
					REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		DESIGN BRADLEY		90/9/31	
					GENERAL				STRESS		TITLE BRACKET	
					LIMITS				CHECKED BRADLEY		9/16/8	
					1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .015 MAX 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7742 5. HOLES PER AND 10387		1. TOLERANCES — .XX ± .030 2. ANGLES ± .1° 3. PARALLELISM ± .0075 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		CLIENT		CODE	
					REPORT ALL DISCREPANCIES — DO NOT SCALE						DWG NO. D2012-111	
											SCALE	
											REV. A	

REDRAWN FROM
D2012-111 JUN 3/92